

Date:
User:Tuesday, 16/09/2008 3:25:43 PM
Julie Leococq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : AFT BASE ASS'Y

Job Number : 42040-3

Estimate Number : 13043

P.O. Number :

This Issue : 16/09/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL / MED FAB

Previous Run : 39931

Part Number : D3651041

Drawing Number : D3651 REV.B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 30/10/2008

Qty: 43 Um: Each

Written By :

Checked & Approved By : JUD 08.9.16

Comment :

Est Rev:A New Issue 07-09-27 DD verified by: EC

Est Rev:B ECN 1113P 08-01-22 DD verified by: EC

Est Rev:C ecn1162 08-04-02 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0 D3651043

Flange Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

FLANGE ASSEMBLY B 40856

FF 08/10/02

3.0 D36511

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

GASKET

B 42115

SB 08/11/19 (B)

4.0 D36519

Inside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

DOUBLER

(1) B 37138

B 42118

SB 08/11/19 (C)

5.0 D365111

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

GASKET

B 39938 / B 37139 / 42116 (x4)

SB 08/11/19 (G)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASSY

Job Number: 42040

Part Number: D3651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D365113

Outside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

DOUBLER

①

B 37140

B 42117

⑤

SB 08/11/19

⑥

7.0

CR3523402

RIVET



Comment: Qty.: 58.0000 Each(s)/Unit Total: 290.0000 Each(s)

RIVET

~~M109371~~

SMALL & MEDIUM FAB RESOURCE 1

SB 08/11/19

⑥

8.0

SMALL FAB 1



Comment: 1-Assemble as per dwg D3651

2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651

Batch: M109536

3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651

Batch: M105823

FF 08/11/20

3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/20

④

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: COA

SB 08/11/20

③

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/21

mf 08-11-20

Job Completion



8 7 6 5 4 3 2 1

D

C

B

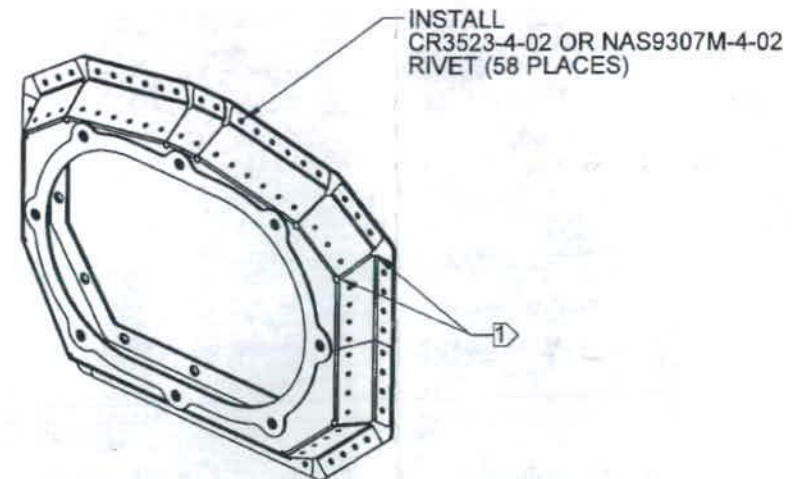
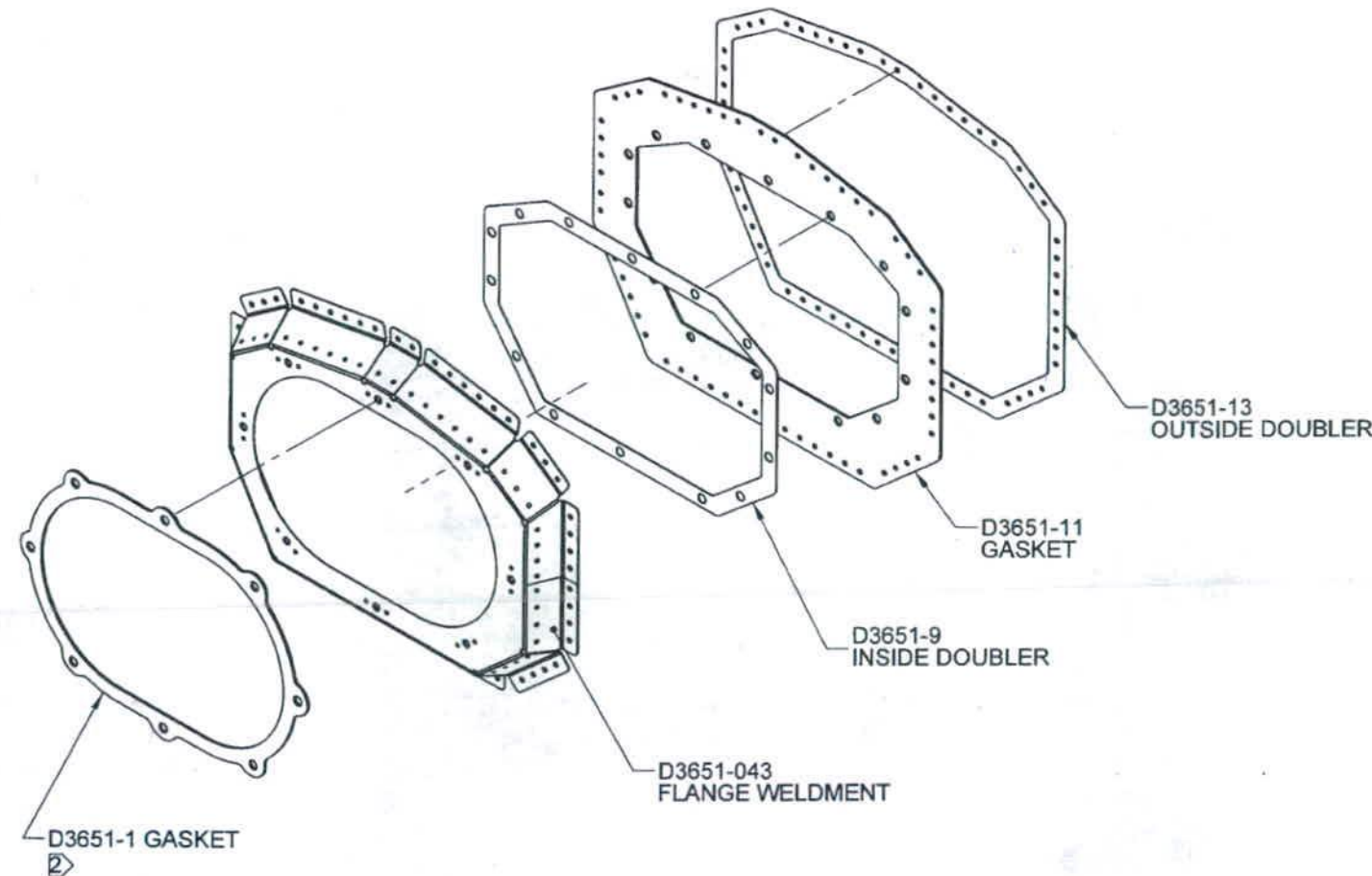
A

D

C

B

A



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

RELEASED
08.03.27/MPD

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. 42040

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